

Date: Friday, 22/05/2009 4:45:41 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW MOD KIT
Job Number : 48154	
Estimate Number : 11182	
P.O. Number :	Part Number : D350615041
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D350-615
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 47861	Material :
Written By :	Due Date : 19/06/2009 Qty: 50 Um: Each
Checked & Approved By : <u>JUL 09.05.25</u>	
Comment : Est Rev:K Removed Manufacturing 05-12-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUL 09.06.11 (50)



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003

2.0	48154A	"T" HANDLE ASSEMBLY
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Comment: Sub-Component "T" HANDLE ASSEMBLY

1 x D2282-041 Batch B 48154A

3.0	48154B	SADDLE ASSEMBLY
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Comment: Sub-Component SADDLE ASSEMBLY

1 x D2282-043 Batch B 48154B

4.0	D30153	Locknut
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 150.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3015-3 5/16 Locknut B 48111 (83)

M 48238 (674)

5.0	D30155	SS Nylock Nut 7/16
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-5 7/16 Locknut M 48112 (83)

M 48112 (83)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GHW MOD KIT

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Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

51618015C

SS Bolt 5/16-18 1.5" L



Comment: Qty.: 3.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long M111530

Ep 09/06/10

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 12.0000 Each(s)/Unit Total : 600.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer M111876

Ep 09/06/10

8.0

71614050C

SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long M110729

(354)

M111576 (152)

Ep 09/06/10

9.0

716WC

SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer M110458

1 D2282-041(Ref) "T" Handdle Assembly B48154A

1 D2282-043 (Ref) Saddle Assembly B48154B

Ep 09/06/10

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

Ep 09/06/10

(50)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep 09/06/10

counts
(x50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2 per box 25 boxes see Seq 1-0

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location:

PPP Rev:

R

PC 4/6/11

(50)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/12

Job Completion



U 09.06.12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MBY	APPROVED BW	DRAWING NO. D350-615	REV. B SHEET 1 OF 2
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SCALE NTS
A	95.03.23	NEW ISSUE	
B	97.10.21	CHANGE NUMBERING SCHEME	

-041	Part No.	Description
X	D350-615-041	Ground Handling Wheel Mod.
1	D2282-041	"T" ASSEMBLY
1	D2282-043	SADDLE ASSEMBLY
3	5/16-18-015C	5/16 BOLT 1.5 LONG
3	5/16-18NC	5/16 LOCKNUT (D3015-3)
12	5/16WC	5/16 WASHER
1	7/16-14-050C	7/16 BOLT 5.0 LONG
1	7/16-14NC	7/16 LOCKNUT (D3015-5)
2	7/16WC	7/16 WASHER

THESE INSTRUCTIONS ARE TO BE USED IN CONJUNCTION WITH
THE AIRCRAFT MAINTENANCE AND OVERHAUL INSTRUCTION MANUAL
AC43.13.1A & 2A ACCEPTABLE METHODS, TECHNIQUES, AND PRACTICES

INSTALLATION:

1. Remove existing ground handling wheel pump saddle.
2. Replace saddle with D350-615-041.
3. Torque 5/16 bolts to bottom, then back-off half turn to allow easy rotation without excessive play.

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. **H8154**



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>KE</i>	DRAWING NO. D350-615	REV. B
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SHEET 2 OF 2
		SCALE	NTS

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)

EXISTING PUMP
BODY

D2282-043 SADDLE
ASSEMBLY

NO. 248154
WARRANTY
NOTICE
FOR
REPAIR
TO
BE
MADE
BY
DART
AEROSPACE
LTD.
VICTORIA
INTERNATIONAL
AIRPORT
CANADA